

Date: Tuesday, 12/6/2005 9:56:24 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE ASSEMBLY
Job Number :	25128B		
Estimate Number :	11180		
P.O. Number :	N/A	Part Number :	D2282043
This Issue :	12/6/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2282 REV E
First Issue :	N/A	Project Number :	N/A
Previous Run :	25127B	Drawing Revision :	E
	Type :	Material :	N/A
	SMALL / MED FAB	Due Date :	1/18/2006
Written By :	<u>SEE COMMENT BELOW</u>		Qty: 98 100 Um: Each
Checked & Approved By :	<u>SEE COMMENT BELOW</u>		
Comment :	Est Rev:A Removed from 9 Digit 05-12-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2281	Jack Saddle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2281	Saddle	B25132

CPL 06-01-17

2.0	D22827	Tube
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2282-7	tube	B25135

CPL 06-01-17

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

Grind chamfers and ensure full penetration.

A/R	ER316L SS	Filling Rod	M13066 M19174
		Dwg Rev:	E

CPL 06-01-17

4.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

M06/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2282-043 PAR #: _____ Fault Category: Prod. PAR. ASS" Large NCR: Yes No DQA: D Date: 06/01/23
 QA: N/C Closed: JA Date: 06.01.24

NCR: <u>25128B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-17	3	2 parts damaged (D2281) no good to weld. Damaged by stacking Jack saddles too tightly together.	<u>JB</u> <u>06-01-17</u>	Scrap and destroy.	<u>2</u> <u>06-01-17</u>	<u>2</u> <u>06-01-17</u>	<u>JB</u> <u>06-01-17</u>	<u>2</u> <u>06-01-17</u>

NOTE: Date & initial all entries

Date: Tuesday, 12/6/2005 9:56:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 25128B

Part Number: D2282043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

DL 06/01/22 98

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

DL 06/01/23 98

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/23 98

06/01/24

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____




QA: N/C Closed: _____ Date: _____

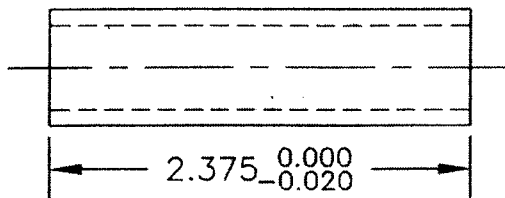
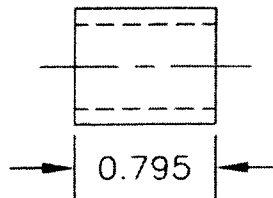
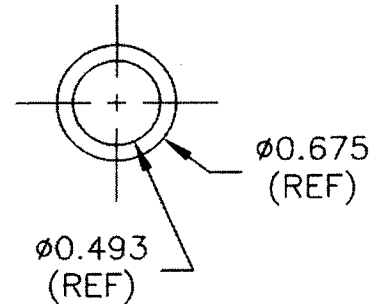
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

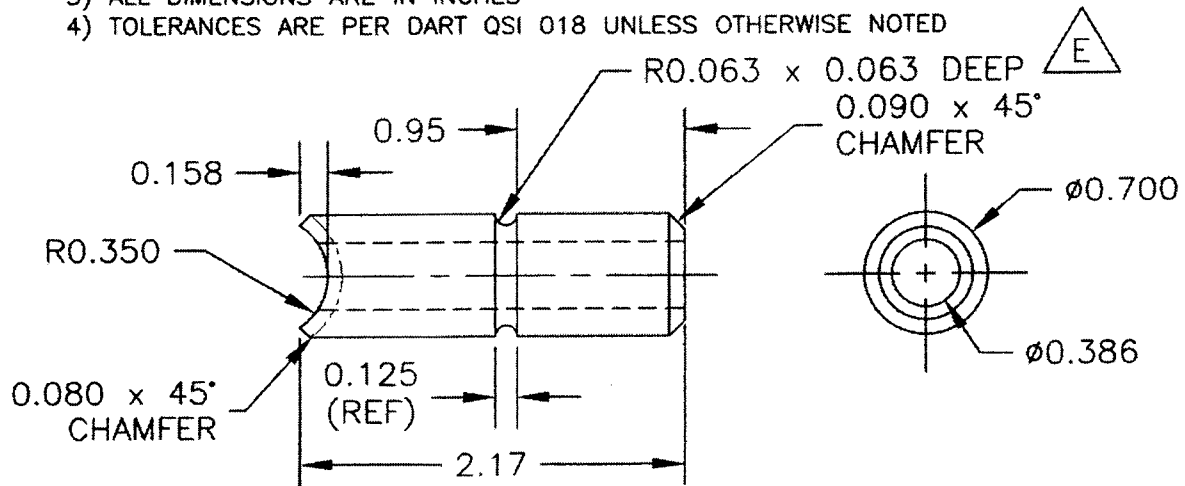
DART**RELEASED**

05/09/16

DESIGN BW	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07-	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

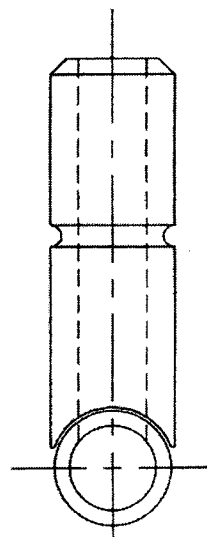
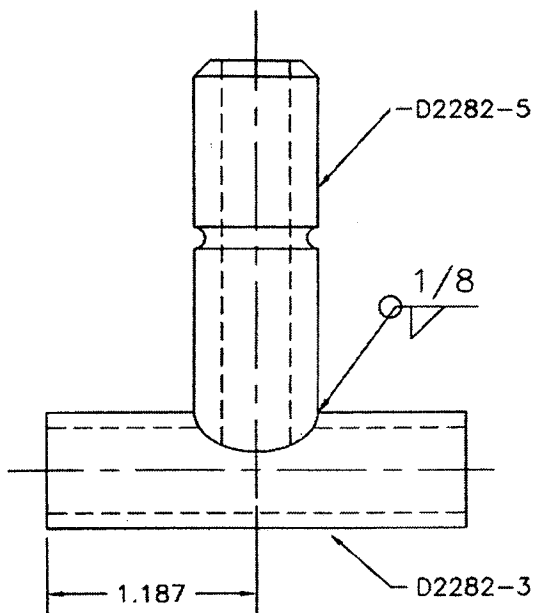
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

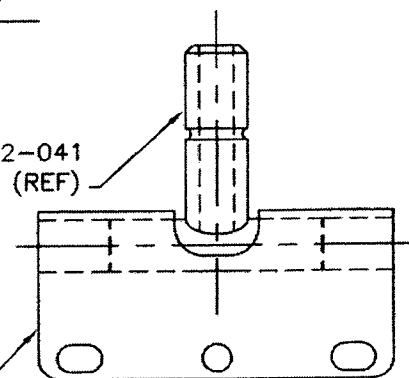
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



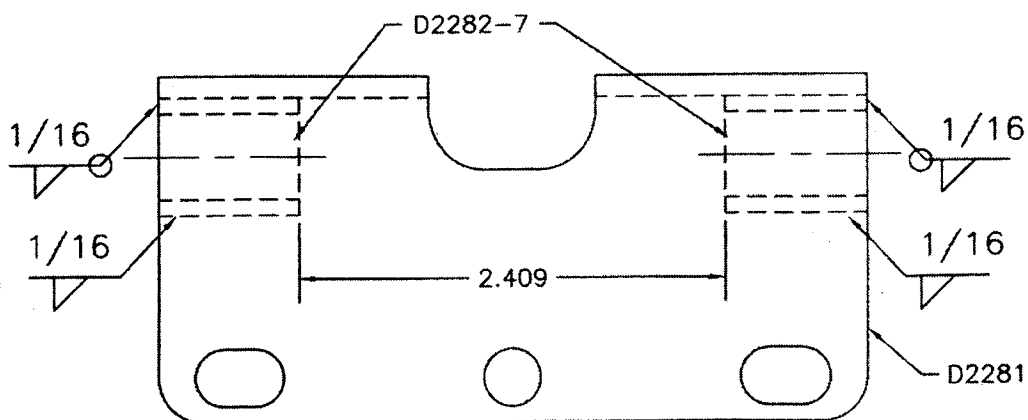
D2282-041
(REF)

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

D2282-043
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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